



Dart Aerospace Ltd.
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K6A 1K7
Canada

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RB500N9506-1M
Job Sheet 204218



Part No: RB500N9506-1M

Job Qty: 2 pcs **3** **DAS**
21
3-89

Part Name: Notar Fan Nut Socket (Modified)



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 12/5/19

Job Tracking No:

Due Date: 12/18/19

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG RB500N9506-1M Rev 5 IPP Rev. A 19.04.23 New issue DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Small Fab - 1	2 pcs	12/18/19		0.00	0.08	Small Fab - 1		<i>ML</i>
							Small Fab - 2		
							Small Fab - 3		
							Small Fab - 4		
							Small Fab - 5		
							Small Fab - 6		
							Small Fab - 7		
							Small Fab - 8		
							Small Fab - 9		
110	QC 5	2 pcs	12/18/19		0.00	0.00	QC 5 - 10		
							QC 5 - 12		
							QC 5 - 17		
							QC 5 - 18		
							QC 5 - 19		
							QC 5 - 22		
							QC 5 - 24		
							QC 5 - 3		
							QC 5 - 43		
							QC 5 - 49		
							QC 5 - 51		
							QC 5 - 58		
							QC 5 - 68		
							QC 5 - 9		
							QC 5 - 50		
							QC 5 - 30		
							QC 5 - 40		
							QC 5 - 61		
							QC 5 - 81		
130	Packaging 3-2 - Stock - B4B	2 pcs	12/18/19		0.00	0.00	Packaging 3 - 1 - B4B		
							Packaging 3 - 2 - B4B		
							Packaging 3 - 3 - B4B		



Container No: S238523



Part: RB500N9506-1M

Job No: 204218

Serial No/Batch: S238523

Revision: 5

Inspector:

Exp Date:

Instructions:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Date: 12/09/19

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					Packaging 3 - 4 - B4B	
					Packaging 3 - 5 - B4B	
					Packaging 3 - 6 - B4B	DAS
					Packaging 3 - 7 - B4B	28
					Packaging 3 - 8 - B4B	9-09
					Packaging 3 - 9 - B4B	
					Packaging 3 - 10 - B4B	
					Packaging 3 - 11 - B4B	
					Packaging 3 - 12 - B4B	
					Packaging 3 - 13 - B4B	
					Packaging 3 - 14 - B4B	
					Packaging 3 - 15 - B4B	
					Packaging 3 - 16 - B4B	
					Packaging 3 - 17 - B4B	
					Packaging 3 - 18 - B4B	
					Packaging 3 - 19 - B4B	
					Packaging 3 - 20 - B4B	
					Packaging 3 - 21 - B4B	
					Packaging 3 - 22 - B4B	
					Packaging 3 - 23 - B4B	
					Packaging 3 - 24 - B4B	
					Packaging 3 - 25 - B4B	
					Packaging 3 - 26 - B4B	
					Packaging 3 - 27 - B4B	
					Packaging 3 - 28 - B4B	
					Packaging 3 - 29 - B4B	
					Packaging 3 - 30 - B4B	
					Packaging 3 - 31 - B4B	
					Packaging 3 - 32 - B4B	
					Packaging 3 - 33 - B4B	
					Packaging 3 - 34 - B4B	
					Packaging 3 - 35 - B4B	
					Packaging 3 - 36 - B4B	
140 QC 21 - FG	2 pcs	12/18/19	0.00 0.00		QC 21 - FG - 21	
					QC 21 - FG - 70	DAS
					QC 21 - SA - 53	21

DEC 11 2019

Part Op 100 - (Small Fab) Assemble as per drawing. See note 1.
 Descriptions: 110 - (QC5- Inspect part completeness to step on W/O)
 130 - (Identify as per dwg & Stock Location: _____) Identify and Stock
 140 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
90248A086	Thread-Locking Insert, 1/2-20 Thread X 3/4-10 Tap X 21/32	2 Ea (1 ea)	100-Small Fab - 1	5215205
91257A501	Bolt	2 pcs (1 ea)	100-Small Fab - 1	5042371
94744A289	Washer, Ø1/2 X 1-1/4 O.D.	2 Ea (1 ea)	100-Small Fab - 1	5215207
RB500N9506-1M-1	Nut Socket	2 pcs (1 ea)	100-Small Fab - 1	5231508
RB500N9506-1M-3	Guide	2 pcs (1 ea)	100-Small Fab - 1	5227720

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Small Fab - 1	90248A086	2	3	0
	91257A501	2	12	0
	94744A289	2	3	0
	RB500N9506-1M-1	2	3	0
	RB500N9506-1M-3	2	3	0

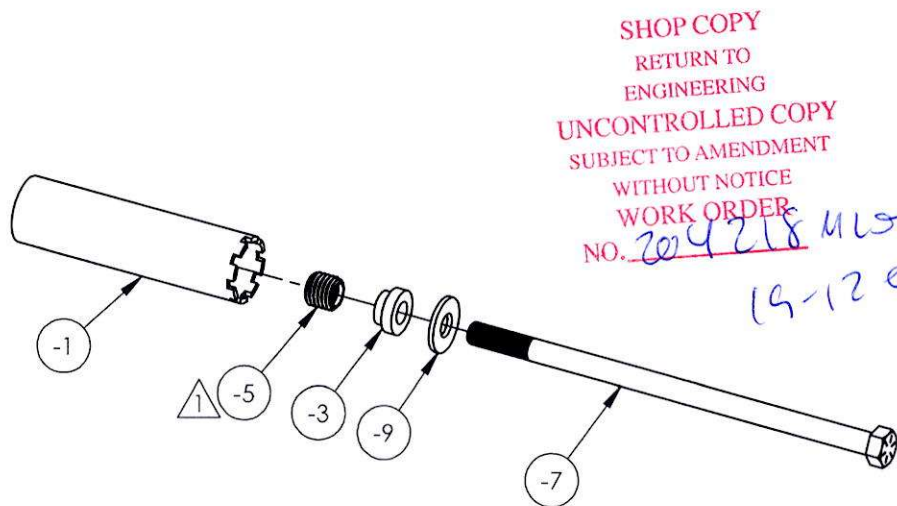
Part Specifications

Specifications could not be found.

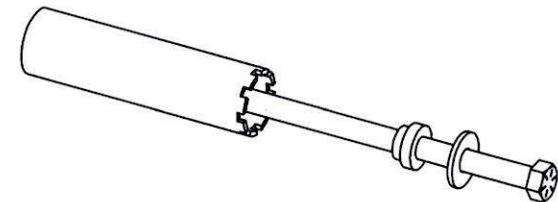
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REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
1		ADDED ASSEMBLY VIEW.	8/31/2006	WP	
2		INSTALLED NEW DRAWING FORMAT, REDUCED FROM 3 PAGES, ADDED LOCTITE NOTE.	9/23/2008	WP	RW
3		-1 CH'D CLEARANCE DIAMETER FROM Ø.656 TO Ø.672, CH'D ENGRAVE NOTE.	5/16/2012	RJC	GE
4		-1 CH'D THRU HOLE WAS Ø.532 IS Ø.484. -3 CORRECTED GUIDE WAS SAME AS RB500N9605-3 IS SAME AS RB500N9505-1M-3.	8/6/2013	RJC	GE
5	16-0206	CH'D TITLE WAS DRIVE SHAFT COUPLER SOCKET ASSEMBLY IS NOTAR FAN NUT SOCKET (MODIFIED), DELETED TOOL USE NOTE. -1 CH'D DIM WAS Ø1.485 ± .015/- .005 IS Ø1.49, WAS .700 IS .70, WAS Ø.672 IS Ø.68, WAS .150 IS .150, WAS Ø.484 THRU Ø.76 X 120° BROACH, .500 SQ. IS 2X .508/.503, ADDED MISSING DIM R.13, 2X .470 MIN., ADDED FINISH SPEC QMSI-6.2.2, B.O. REV D, CH'D MATERIAL WAS 41L40 RND. BAR IS 4140/4142. -3 CH'D DIM WAS Ø.500 THRU IS Ø.500 ± .005/- .000 THRU, ADDED FINISH SPEC QMSI-6.2.2, B.O. REV D, ADDED P/N'S -5, -7, -9 TO BUYOUTS, CH'D -5 DESCRIPTION TO THREAD-LOCKING INSERT.	11/2/2016	RJC	SM



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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 204218 MLS
19-12-05



NOTE:

1 LOCTITE INTO -1.

DART AEROSPACE	
TITLE NOTAR FAN NUT SOCKET (MODIFIED)	
DWG NO. RB500N9506-1M	REV 5
MAT'L HEAT TREAT FINISH SPEC	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES .XXX ± .005 FRACTIONS ± 1/8 .XX ± .01 ANGLES ± .5° .X ± .1 SURFACES = 125/
DRAWN BY: CLOUGH	1. BREAK ALL SHARP EDGES .015 x 45° OR .015R
CHECKED: DUERFELDT	2. DIMENSIONAL LIMITS APPLY AFTER PLATING
OPPS APPR: ANDERSON	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
QA APPR: LINDSAY	USED ON MODEL
APPROVED: MACKOVJAK	MD-500N NOTAR
SCALE 1:4	DATE 11/1/2016 SHEET 1 OF 3

ASSY QTY	ASSY QTY	B/O	Part #	UNIT QTY	Description	Material	B/O INFORMATION OR SPECIFICATIONS	PG.
			-1	1	SOCKET	4140/4142		2
			-3	1	GUIDE	STRESSPROOF		3
		B/O	-5	1	THREAD-LOCKING INSERT	STEEL	1/2-20 THREAD X 3/4-10 TAP X 21/32 (MCMASTER-CARR #90248A086)	1
		B/O	-7	1	HEX HEAD CAP SCREW	STEEL GRD. 8	1/2-20 X 10 (MCMASTER-CARR #91257A501)	1
		B/O	-9	1	WASHER	STEEL	Ø1/2 X 1-1/4 O.D. (MCMASTER-CARR #94744A289)	1

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date :	Sequence #:	QTY Affected :		MRB (QSI042)	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
				QC / QA Coordinator	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Presservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐ ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread		Other/Details:			